

De rev 54669

Work Order ID 53798

November 18, 2009 12:43:49 PM



Page 1

Item ID: D2585

Accept



Revision ID: B

Setup

Start



Item Name: Mounting Channel

Stop



Start Date: 18/11/2009 Start Qty: 30.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan: *B*

Date: 08/11/09 Tooling: _____ Date: _____

Run

Start



QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2585	Rev B

100 0.00



FLOW WATER JET

Waterjet

Memo 0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2585

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

HB 9-12-4

Eb 09/12/07

110 0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo 0.00

Quality Control

HB 9-12-4

120 0.00



QC8- Inspect parts - second check

0.00

QC

Memo 0.00

Quality Control

2011207

locutor

(X6)

f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53798

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Item ID: D2585

Accept



Setup Start



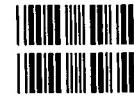
Revision ID: B

Stop



Item Name: Mounting Channel

Start Date: 18/11/2009 Start Qty: 30.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
	Memo	0.00							
	Deburr if necessary								
140	NC BRAKE	0.00							
	Memo	0.00							
	Form as per Dwg D2585								
150	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
	Quality Control								

N/A/S

SB 09/12/15

60 0

center

460

→ SB 09/12/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53798

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November 18, 2009 12:43:49 PM

Item ID: D2585

Accept



Setup Start



Revision ID: B

Stop



Item Name: Mounting Channel

Start Date: 18/11/2009 Start Qty: 30.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Identify as per dwg & Stock Location: _____ Packaging	0.00							<i>9/12/15</i> <i>OK</i> <i>SL</i>
	Memo	0.00							
170 	QC21- Final Inspection - Work Order Release QC	0.00							<i>09/12/17</i> <i>JF</i>
	Memo	0.00							
	Quality Control								<i>MF</i> <i>09-12-16</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

November 18, 2009 12:43:55 PM

Work Order ID: 53798



Parent Item: D2585RevB



Parent Item Name: Mounting Channel

Start Date: 18/11/2009

Required Date: 25/11/2009

Comments:

Start Qty: 30.00

Required Qty: 30.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S14GA		Purchased		No		100	sf	25.9521	0.4958	1.5		189-124

304SS sheet .080



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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Location

Main Warehouse

MAT	25.9521
110993Q	25.9521

110993

(60)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	53798
Description: Mounting Channel	Part Number:	D2585
Inspection Dwg: D2585 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	9-12-04	Date:	09/12/07	Date:	N/A

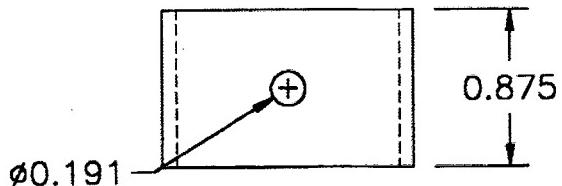
Rev	Date	Change	Revised by	Approved
A	06.08.29	New Issue	KJ/JLM	SJL

DART

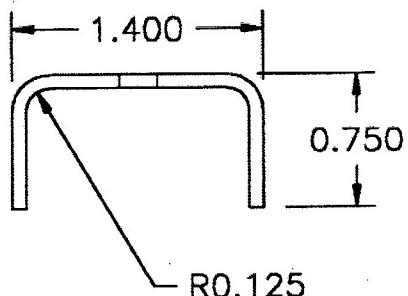
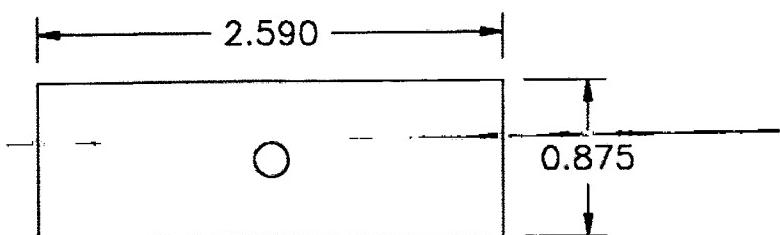
DESIGN BW	DRAWN BY <i>BW</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED <i>BW</i>	DRAWING NO. D2585	REV. B SHEET 1 OF 1
DATE 96/07/11	TITLE MOUNTING CHANNEL		SCALE 1:1
B	97/03/14	ADD FLAT PATTERN	

RELEASED

97/03/14 DS



SHOP DRAWING
RETURN TO
ENGINEER
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK NO. 53798
BJ 09-11-18

FLAT PATTERN

MATERIAL: 304/316 SS, 14 GAUGE (0.078)